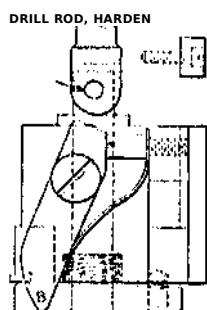


be made of cast iron and kept in stock in various sizes to meet the requirements of the shop whenever this is practicable. Clamping cams, dowel pins, bolts, and screws should be made up in large quantity, and steel seat blocks, straps and other steel parts should be made of standard stock sizes, if possible, to prevent unnecessary machining.

©

Machinery

**Fig. 1. Detachable Vise
Jaws for Us© in cutting off
Bar Stock**



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Fig. 2. Straddle-milling Fixture

Detachable Jaws for Vise.
- - The cheapest kind of milling fixture that can be built is a pair of detachable vise jaws, as shown in Fig. i.

These jaws are made of cold-rolled steel and casehardened. They can be removed from the vise quickly and replaced by other jaws. It is advisable, however, to use vise jaws only where great accuracy is not required, such as